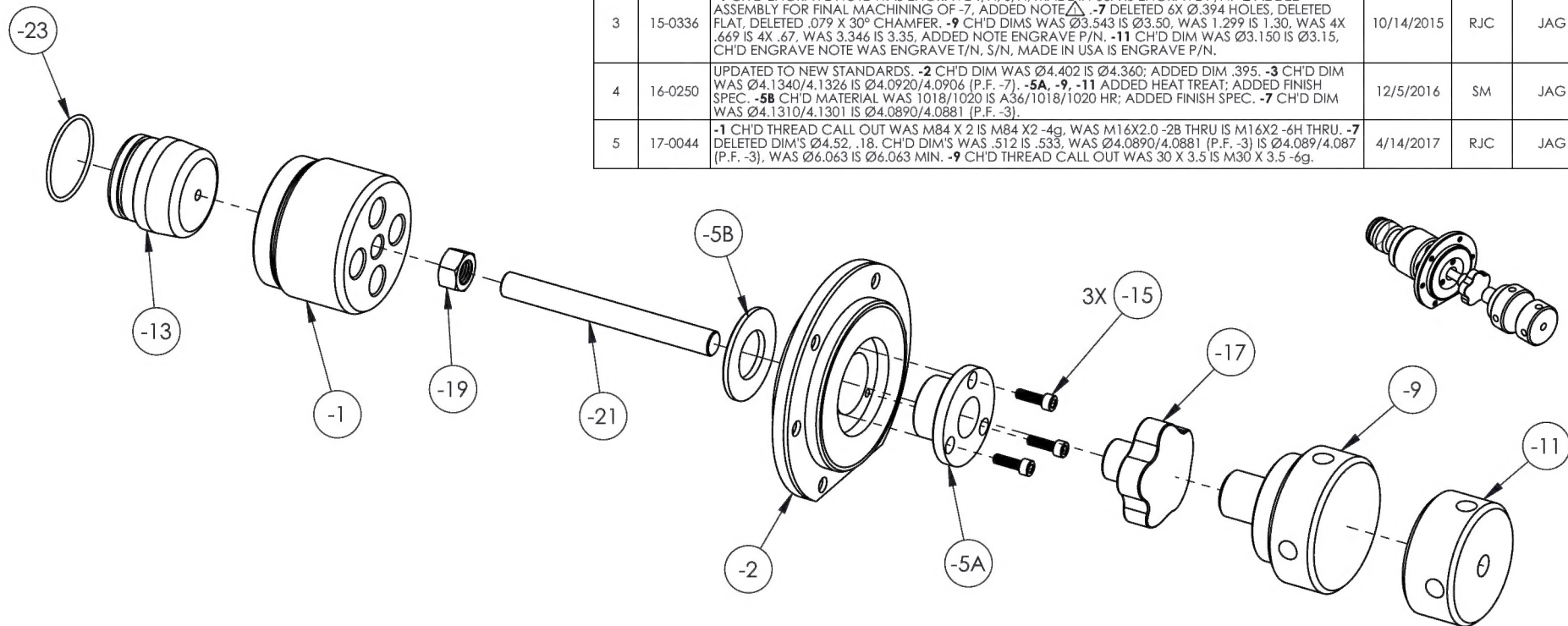


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D DIM WAS M16 X 1 IS M16 X 2, ADDED MISSING DIM B.C. Ø1.929. -5A CH'D DIM WAS Ø2.5215-2.5208 IS Ø2.5185 +.000-.005, WAS Ø1.5764-1.5758 IS Ø1.5730-1.5724. -7 ADDED MISSING HOLE DIM 6X Ø.394 AND CHAMFER .03 X 45°, CH'D DIM WAS Ø6.063 IS {Ø6.063}.	9/28/2012	RJC	SE
2	15-0172	-5A CH'D DIM WAS M6 X 1 [ ] .433 [ ] .236 {3X} IS 3X Ø.252 THRU [ ] .43 [ ] .24.	7/17/2015	RJC	JAG
3	15-0336	-1 CH'D ENGRAVE NOTE WAS ENGRAVE T/N, S/N, MADE IN USA IS ENGRAVE P/N. -2 ADDED ASSEMBLY FOR FINAL MACHINING OF -7, ADDED NOTE [ ] . -7 DELETED 6X Ø.394 HOLES, DELETED FLAT, DELETED .079 X 30° CHAMFER. -9 CH'D DIMS WAS Ø3.543 IS Ø3.50, WAS 1.299 IS 1.30, WAS 4X .669 IS 4X .67, WAS 3.346 IS 3.35, ADDED NOTE ENGRAVE P/N. -11 CH'D DIM WAS Ø3.150 IS Ø3.15, CH'D ENGRAVE NOTE WAS ENGRAVE T/N, S/N, MADE IN USA IS ENGRAVE P/N.	10/14/2015	RJC	JAG
4	16-0250	UPDATED TO NEW STANDARDS. -2 CH'D DIM WAS Ø4.402 IS Ø4.360; ADDED DIM .395. -3 CH'D DIM WAS Ø4.1340/4.1326 IS Ø4.0920/4.0906 (P.F. -7). -5A, -9, -11 ADDED HEAT TREAT; ADDED FINISH SPEC. -5B CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020 HR; ADDED FINISH SPEC. -7 CH'D DIM WAS Ø4.1310/4.1301 IS Ø4.0890/4.0881 (P.F. -3).	12/5/2016	SM	JAG
5	17-0044	-1 CH'D THREAD CALL OUT WAS M84 X 2 IS M84 X2 -4g, WAS M16X2.0 -2B THRU IS M16X2 -6H THRU. -7 DELETED DIM'S Ø4.52, .18, CH'D DIM'S WAS .512 IS .533, WAS Ø4.0890/4.0881 (P.F. -3) IS Ø4.089/4.087 (P.F. -3), WAS Ø6.063 IS Ø6.063 MIN. -9 CH'D THREAD CALL OUT WAS 30 X 3.5 IS M30 X 3.5 -6g.	4/14/2017	RJC	JAG

# NOTES:

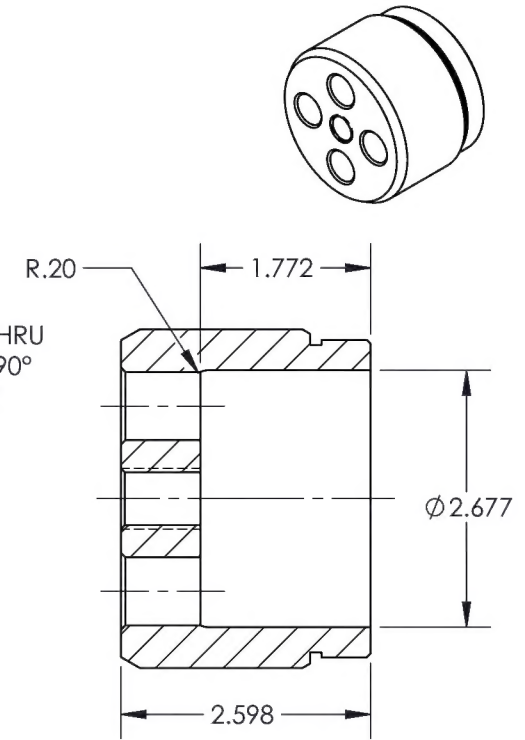
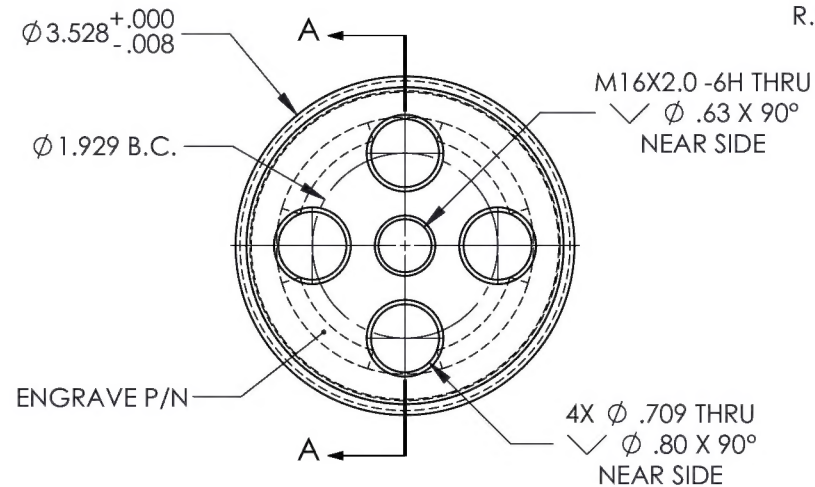
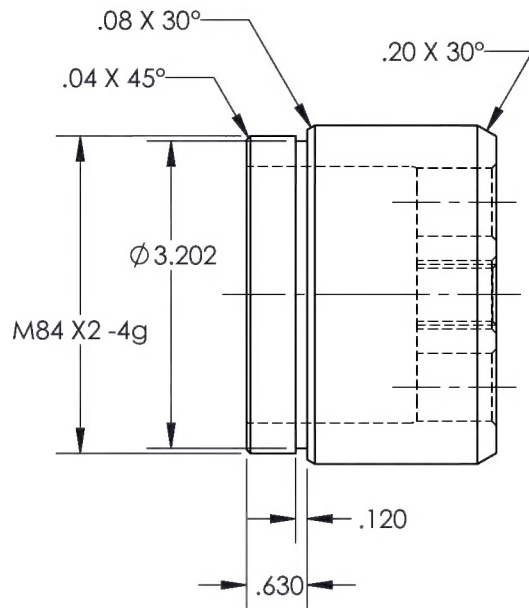
1. RBW6522A00231-W142AJ-3T REPLACES AGUSTA T/N: 3T6522A00231-W142AJ.
2. ALSO IN KIT RBW6505G00231-3T.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	6061		2
	X		-2	1	BASE PLATE ASSEMBLY			3
	1		-3		BASE PLATE	6061		4
			-5A	1	INSERT	4140/4142		5
			-5B	1	COVER	A36/1018/1020 HR		6
	1		-7		PAD	NYLON		7
			-9	1	LARGE KNOB	4140/4142		8
			-11	1	SMALL KNOB	4140/4142		9
			-13	1	CUP	6061		10
		B/O	-15	3	SOCKET HEAD CAP SCREW	STEEL	M6 X 1 X 20mm {MCMaster-CARR #91290A326}	1
		B/O	-17	1	5 LOBE KNOB	CAST IRON	M16 X 2.0 x 28mm J.W. WINCO #16NC81/E	1
		B/O	-19	1	HEX NUT	STEEL	M16X2 CLASS 10 {MCMaster-CARR #90685A120}	1
		B/O	-21	1	STUD	STEEL	M16 X 2 X 150mm {MCMaster-CARR #93275A062}	1
		B/O	-23	1	O-RING	VITON	Ø2.156, Ø.096 CROSS SEC. CHRISTOPHER SEALS #V75-136	1
	ASSY -2							

		TITLE	
		TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO.		REV	
RBW6522A00231-W142AJ-3T		5	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY: PERRITT		.X ± .1 SURFACES = 125/	
CHECKED: CLOUGH		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED: GILBERT		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE		USED ON MODEL	
1:4		AW139	
DATE		SHEET 1 OF 10	
10/5/2010			

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 CH'D DIM WAS M16 X 1 IS M16 X 2, ADDED MISSING DIM B.C. Ø1.929.	9/28/2012	RJC	GE
3	15-0336	-1 CH'D ENGRAVE NOTE WAS ENGRAVE T/N, S/N, MADE IN USA IS ENGRAVE P/N.	10/14/2015	RJC	JAG
5	17-0044	-1 CH'D THREAD CALL OUT WAS M84 X 2 IS M84 X2 -4g, WAS M16X2.0 -2B THRU IS M16X2 -6H THRU.	4/14/2017	RJC	JAG



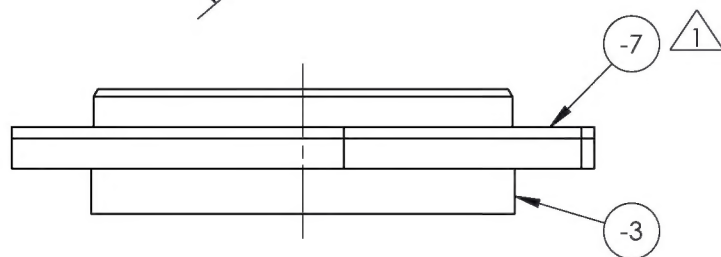
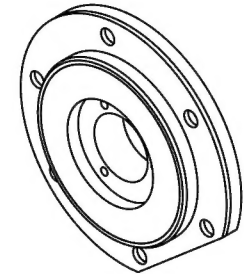
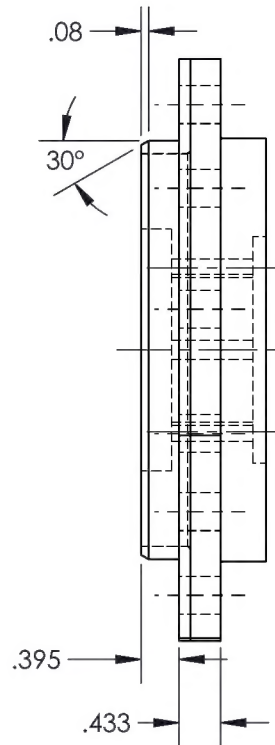
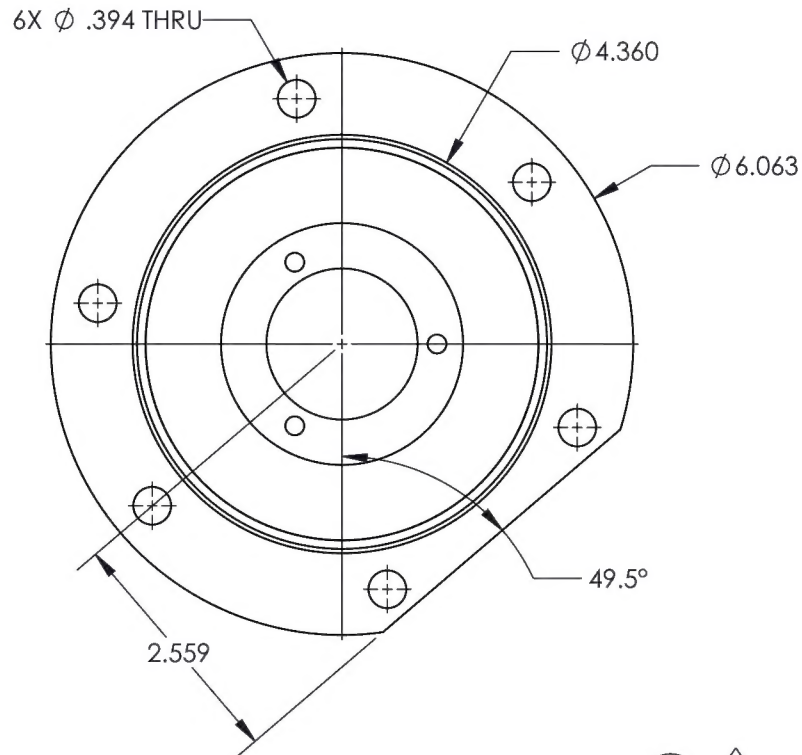
SECTION A-A

(1)  
RECEIVER

<b>DART AEROSPACE</b>	
TITLE TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO. RBW6522A00231-W142AJ-3T-1	REV 5
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK ANODIZE	.XX ± .01 ANGLES ± 5°
SPEC MIL-A-8625, TYPE II, CLASS II	.X ± .1 SURFACES = 125
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	AW139
SCALE 1:8	DATE 10/5/2010
SHEET 2 OF 10	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	15-0336	-2 ADDED ASSEMBLY FOR FINAL MACHINING OF -7, ADDED NOTE 1.	10/14/2015	RJC	JAG
4	16-0250	-2 CH'D DIM WAS Ø4.402 IS Ø4.360; ADDED DIM .395.	12/5/2016	SM	JAG



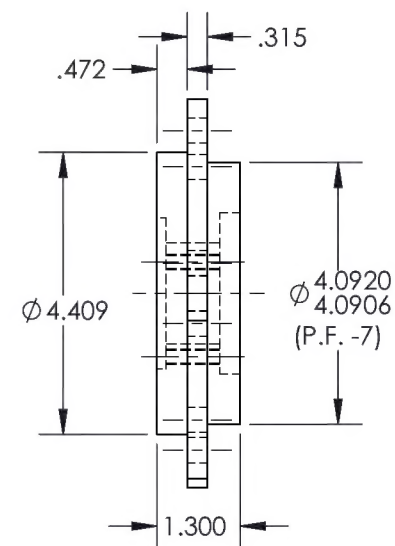
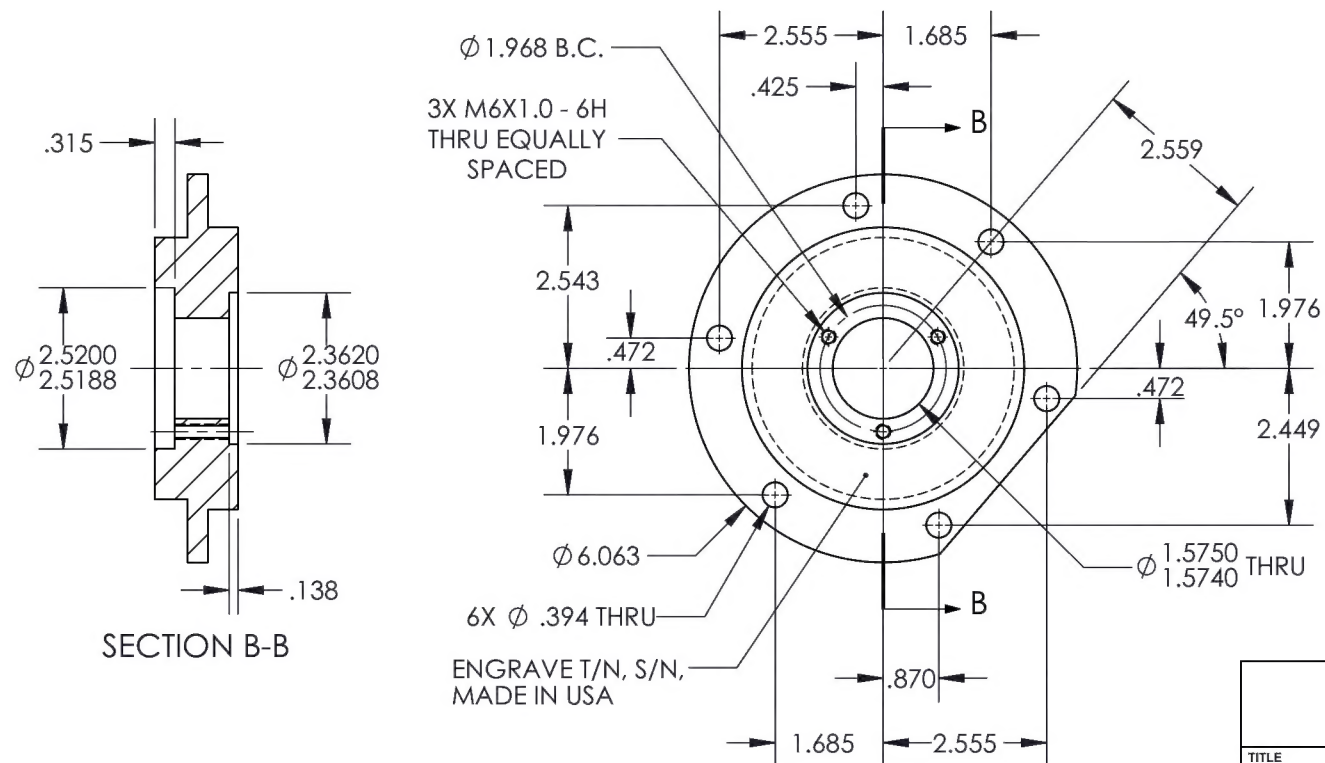
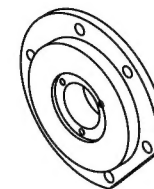
BASE PLATE ASSEMBLY

NOTE:

1 ASSEMBLE -7 ONTO -3. MACHINE -7 TO FINAL DIMENSIONS AS SHOWN USING -3 AS TEMPLATE.

<b>DART</b> AEROSPACE	
TITLE TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO. RBW6522A00231-W142AJ-3T-2	REV 5
MAT'L _____ HEAT TREAT _____ FINISH _____ SPEC _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: CLOUGH	USED ON MODEL
CHECKED: CLOUGH	AW139
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:2	DATE 10/14/2015 SHEET 3 OF 10

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	16-0250	-3 CH'D DIM WAS Ø4.1340/4.1326 IS Ø4.0920/4.0906 (P.F. -7).	12/5/2016	SM	JAG



SECTION B-B

(-3)

BASE PLATE

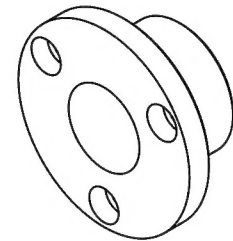
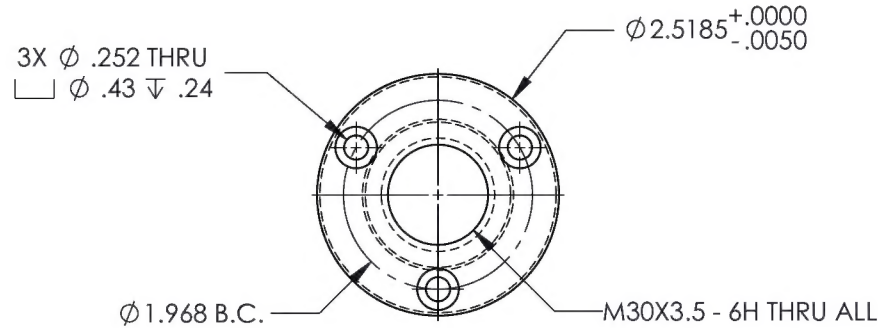
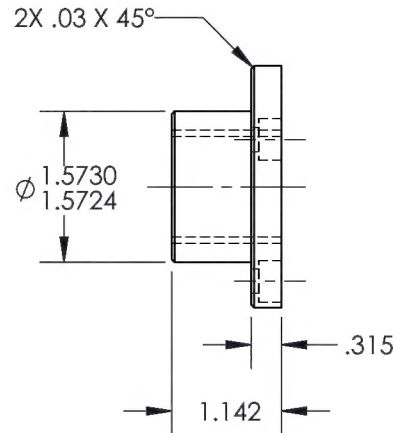


TITLE		TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO.		RBW6522A00231-W142AJ-3T-3	
		REV 5	
MAT'L 6061		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH BLACK ANODIZE		.XX ± .01 ANGLES ± 5°	
		.X ± .1 SURFACES = 125/√	
SPEC MIL-A-8625, TYPE II, CLASS II		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:	PERRITT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED:	CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR:	ANDERSON	USED ON MODEL	
QA APPR:	LINDSAY	AW139	
APPROVED:	GILBERT		
SCALE	1:3	DATE	10/5/2010
		SHEET 4 OF 10	



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5A CH'D DIM WAS Ø2.5215-2.5208 IS Ø2.5185 +.0000-.0050, WAS Ø1.5764-1.5758 IS Ø1.5730-1.5724.	9/28/2012	RJC	SE
2	15-0172	-5A CH'D DIM WAS M6 X 1 $\square$ .433 $\nabla$ .236 (3X) IS 3X Ø.252 THRU $\square$ .43 $\nabla$ .24.	7/17/2015	RJC	JAG
4	16-0250	-5A ADDED HEAT TREAT; ADDED FINISH SPEC.	12/5/2016	SM	JAG



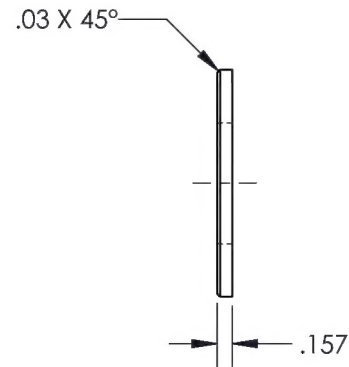
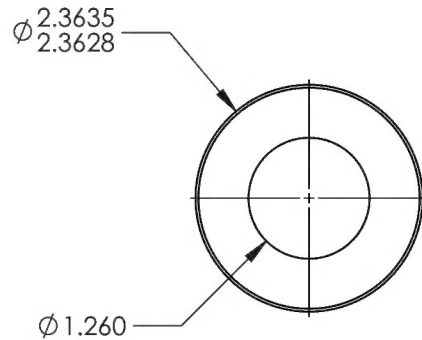
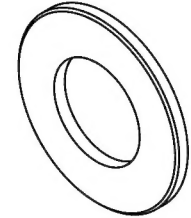
(-5A)

INSERT

<b>DART AEROSPACE</b>	
TITLE TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO. RBW6522A00231-W142AJ-3T-5A	REV 5
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 10/5/2010
	SHEET 5 OF 10

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	16-0250	-5B CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020 HR; ADDED FINISH SPEC.	12/5/2016	SM	JAG

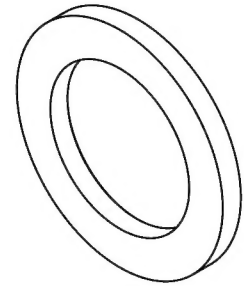
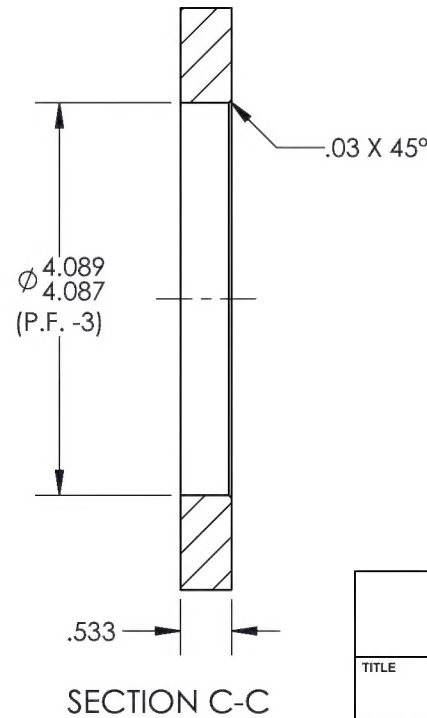
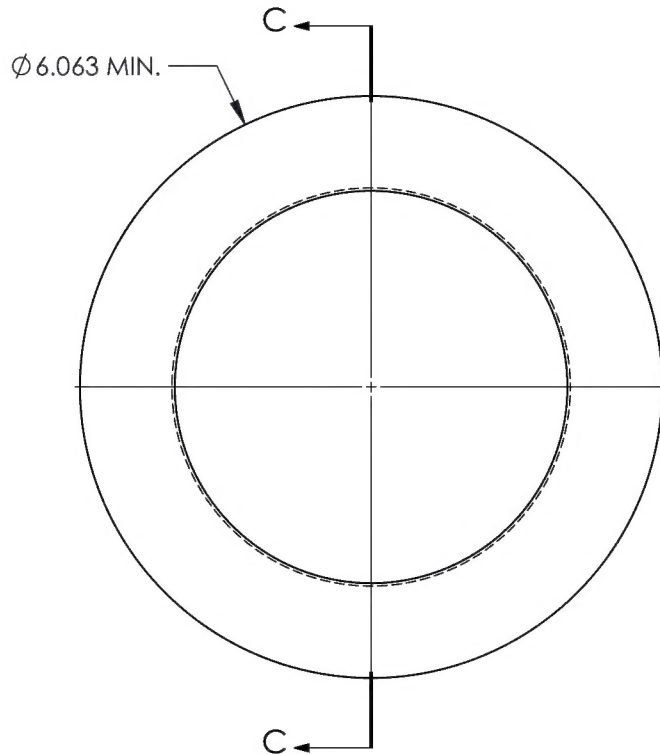


(-5B)  
COVER

<b>DART AEROSPACE</b>	
TITLE TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO. RBW6522A00231-W142AJ-3T-5B	REV 5
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 10/5/2010
	SHEET 6 OF 10

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-7 ADDED MISSING HOLE DIM 6X Ø.394 AND CHAMFER .03 X 45°, CH'D DIM WAS Ø6.063 IS (Ø6.063).	9/28/2012	RJC	SE
3	15-0336	-7 DELETED 6X Ø.394 HOLES, DELETED FLAT, DELETED .079 X 30° CHAMFER.	10/14/2015	RJC	JAG
4	16-0250	-7 CH'D DIM WAS Ø4.1310/4.1301 IS Ø4.0890/4.0881 (P.F. -3).	12/5/2016	SM	JAG
5	17-0044	-7 DELETED DIM'S Ø4.52, .18. CH'D DIM'S WAS .512 IS .533, WAS Ø4.0890/4.0881 (P.F. -3) IS Ø4.089/4.087 (P.F. -3), WAS Ø6.063 IS Ø6.063 MIN.	4/14/2017	RJC	JAG

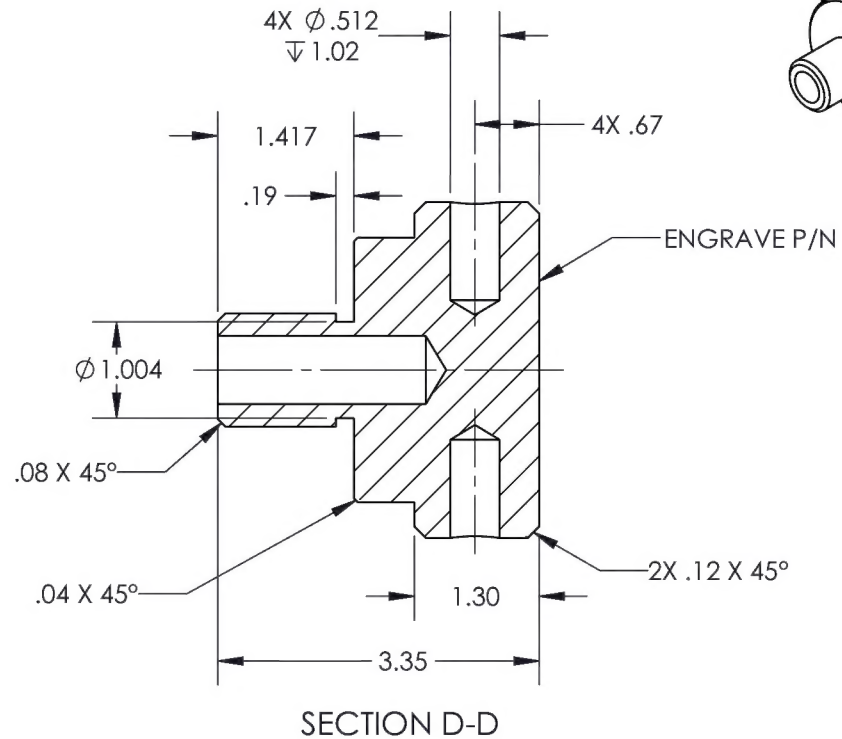
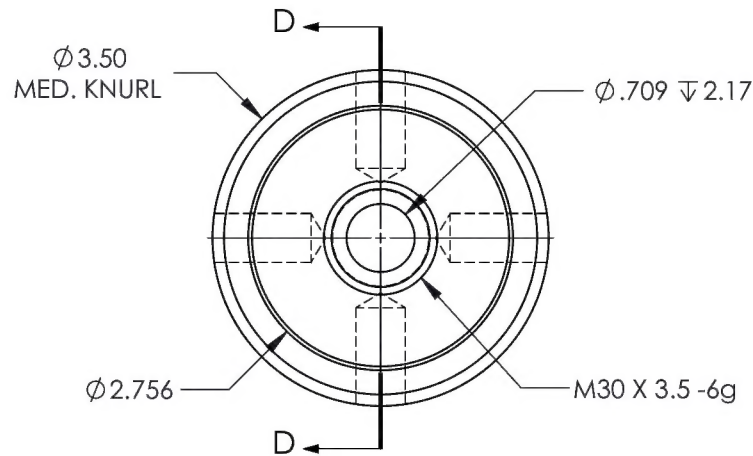


(-7)  
PAD

<b>DART AEROSPACE</b>	
TITLE TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO. RBW6522A00231-W142AJ-3T-7	REV 5
MAT'L NYLON	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 10/5/2010
	SHEET 7 OF 10

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	15-0336	-9 CH'D DIMS WAS Ø3.543 IS Ø3.50, WAS 1.299 IS 1.30, WAS 4X .669 IS 4X .67, WAS 3.346 IS 3.35, ADDED NOTE ENGRAVE P/N.	10/14/2015	RJC	JAG
4	16-0250	-9 ADDED HEAT TREAT; ADDED FINISH SPEC.	12/5/2016	SM	JAG
5	17-0044	-9 CH'D THREAD CALL OUT WAS 30 X 3.5 IS M30 X 3.5 -6g.	4/14/2017	RJC	JAG



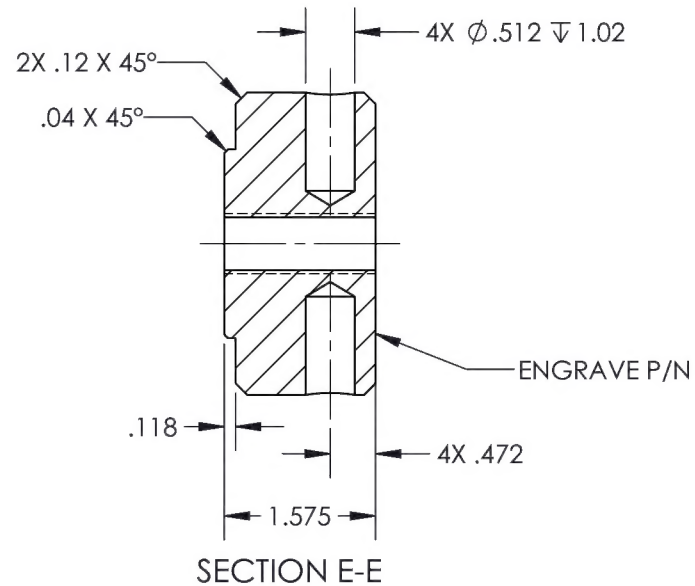
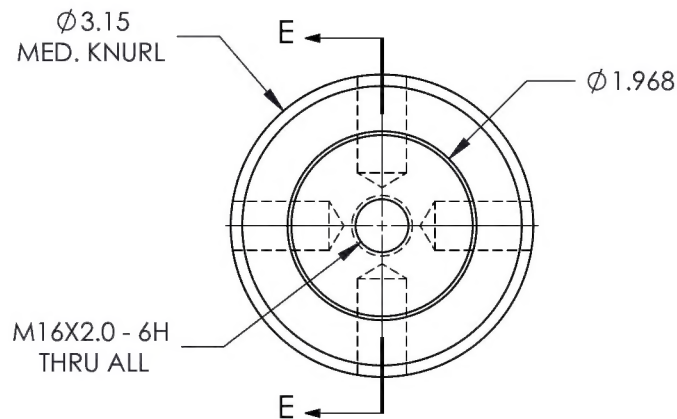
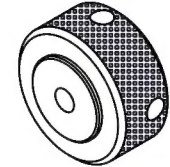
(-9)  
LARGE KNOB

<b>DART AEROSPACE</b>	
TITLE TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO. RBW6522A00231-W142AJ-3T-9	REV 5
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 10/5/2010
	SHEET 8 OF 10



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3	15-0336	-11 CH'D DIM WAS Ø3.150 IS Ø3.15, CH'D ENGRAVE NOTE WAS ENGRAVE T/N, S/N, MADE IN USA IS ENGRAVE P/N.	10/14/2015	RJC	JAG
4	16-0250	-11 ADDED HEAT TREAT; ADDED FINISH SPEC.	12/5/2016	SM	JAG



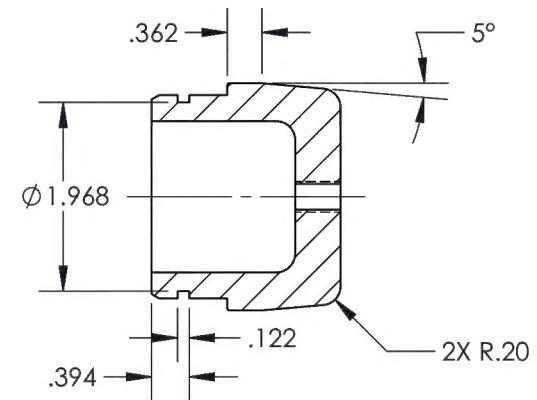
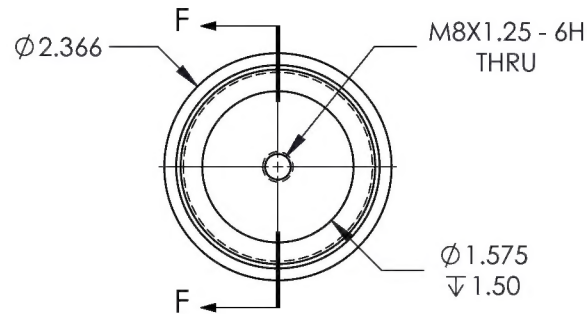
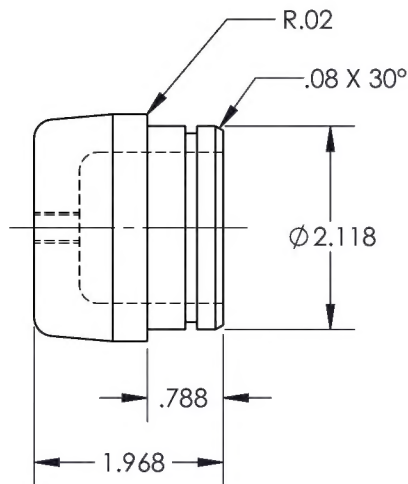
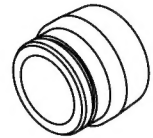
(-11)

SMALL KNOB

<b>DART AEROSPACE</b>	
TITLE TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO. RBW6522A00231-W142AJ-3T-11	REV 5
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	DATE 10/5/2010
	SHEET 9 OF 10

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



SECTION F-F

(13)

CUP

<b>DART AEROSPACE</b>	
TITLE TGB/SERVO ACTUATOR OIL SEAL FIT/EXTRACTION TOOL	
DWG NO. RBW6522A00231-W142AJ-3T-13	REV 5
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625, TYPE II, CLASS II	.XX ± .01 ANGLES ± 5°
DRAWN BY: PERRITT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:2	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 10/5/2010	USED ON MODEL
SHEET 10 OF 10	AW139